

Date: Wednesday, 2/20/2008 4:11:51 PM
 User: Kim Johnston

Process Sheet

12

Customer:	CU-DAR001 Dart Helicopters Services				Drawing Name	FLOAT SKIDTUBE	
Job Number	37503				Part Number	D412742013	
Estimate Number	10366				Drawing Number	N/A	
P.O. Number	:				Project Number	N/A	
This Issue	2/20/2008	S.O. No.	:		Drawing Revision	D	
Prsht Rev.	NC				Material	:	
First Issue	1/1	Type	:	LANDING GEAR	Due Date	3/17/2008	Qty: 1 Um: Each
Previous Run	35745						
Written By	<u>JK</u> 08.02.21						
Checked & Approved By							
Comment	Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev:B 06-06-08 As per DS19336 JLM Est RevC 07-12-03 ECN 1072 DD verified by:JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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08.02.29

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG004

2.0	37503A	FLOAT SKID ASSEMBLY
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Comment: Sub-Component FLOAT SKID ASSEMBLY	<u>37503A</u>
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2571	Saddle, Fwd; Out
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside 36322

AS

08/03/12

5.0	D2572	Saddle, Fwd, In
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside 37283

AS

08/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE		
Job Number: 37503		Part Number: D412742013		
Job Number: 				
Seq. #:	Machine Or Operation:	Description :		
6.0	D2573	Saddle, Aft, Out 		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)				
Pick:				
Qty	Part Number	Description	Batch	
1	D2573	Saddle Aft Outside	<u>35933</u>	<u>AS 08/03/12 (X)</u>
7.0	D2574	Saddle, Aft, In 		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)				
Pick:				
Qty	Part Number	Description	Batch	
1	D2574	Saddle Aft Outside	<u>37567</u>	<u>AS 08/03/12 (X)</u>
8.0	D2876	Saddle Spacer 		
				
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)				
Pick:				
Qty	Part Number	Description	Batch	
2	D2876	Saddle Spacer	<u>35543</u>	<u>AS 08/03/12 (X)</u>
9.0	D2877	Saddle Spacer 		
				
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)				
Pick:				
Qty	Part Number	Description	Batch	
2	D2877	Saddle Spacer	<u>36276</u>	<u>AS 08/03/12 (X)</u>
10.0	D34031	Bushing 		
				
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)				
Pick:				
Qty	Part Number	Description	Batch	
16	D3403-1	Bushing	<u>35634</u>	<u>AS 08/03/12 (X)</u>
11.0	D2747	Set Screw 		
				
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Pick:				
Qty	Part Number	Description	Batch	
4	D2747	Bolt	<u>B3633</u>	<u>AS 08/03/12 (X)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE
Job Number: 37503		Part Number: D412742013
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	D35331	Set Screw
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Set Screw		AS 08/03/12 <input checked="" type="checkbox"/>
13.0	AN4C6A	Bolt
Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Qty Part Number Description Batch		AS 08/03/12 <input checked="" type="checkbox"/>
	16 AN4C6A	Bolt AN4C6A M106519
14.0	AN4C52A	BOLT
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch		AS 08/03/12 <input checked="" type="checkbox"/>
	8 AN4C52A	Bolt M19512
15.0	AN6C12A	BOLT
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch		AS 08/03/12 <input checked="" type="checkbox"/>
	8 AN6C12A	Bolt M104289
16.0	D36723	PHENOLIC WASHER
Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s) PHENOLIC WASHER		AS 08/03/12 <input checked="" type="checkbox"/>
	47.0 AN960C416L	WASHER
Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s) WASHER		AS 08/03/12 <input checked="" type="checkbox"/>
	18.0 D36729	PHENOLIC WASHER
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) PHENOLIC WASHER		AS 08/03/12 <input checked="" type="checkbox"/>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE
Job Number: 37503		Part Number: D412742013
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
19.0	AN960C616L	WASHER
		
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) WASHER	M18918  08/03/12 (X)
20.0	D367211	PHENOLIC WASHER
		
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) PHENOLIC WASHER	B35524  08/03/12 (X)
21.0	MS210434	Nut
		
	Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s) Nut	M167101  08/03/12 (X)
22.0	AN4C7A	Bolt
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt	M106302  08/03/12 (X)
23.0	D34033	Bushing
		
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick:	B35635  08/03/12 (X)
	Qty Part Number	Description
	8 D3403-3	Bushing
24.0	D3405041	Lug Assembly
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick:	B35779  08/03/12 (X)
	Qty Part Number	Description
	1 D3405-041	GHW Lug
25.0	D3405043	Lug Assembly
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick:	B34841  08/03/12 (X)
	Qty Part Number	Description
	1 D3405-043	GHW Lug

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOAT SKIDTUBE
Job Number: 37503		Part Number: D412742013
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
26.0	AN4C46A	BOLT 
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 AN4C46A Bolt M19529 AS 08/03/12 (X)
27.0	MS210434	Nut 
		Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s) Pick: Qty Part Number Description Batch 29 MS21043-4Nut M107101 AS 08/03/12 (X)
28.0	D3407041	Tow Ring 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3407-041 TOW RING B35780 AS 08/03/12 (X)
29.0	D34173	Washer 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3417-3 WASHER B33519 AS 08/03/12 (X)
30.0	D34561	washer 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3456-1 WASHER B33276 AS 08/03/12 (X)
31.0	AN3C37A	BOLT 
		Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s) BOLT M100169 AS 08/03/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 AN3C40A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

M106169

AS 08/03/12 (X)

33.0 AN3C41A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

M106176

AS 08/03/12 (X)

34.0 AN3C42A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

M106169

AS 08/03/12 (X)

35.0 AN3C43A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

M106227

AS 08/03/12 (X)

36.0 AN3C46A BOLT



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

BOLT

M106169

AS 08/03/12 (X)

37.0 AN960C10L washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

washer

M107008

AS 08/03/12 (X)

38.0 MS210433 Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Nut

M107214

AS 08/03/12 (X)

39.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/03/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation:

Description :

40.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: ~~Rev E~~

Rev E

1808/03/13 Si (1)

41.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1808/03/14

Job Completion



1808/03/13 (1)

B37503A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:12:03 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	FLOAT SKID ASSEMBLY		
Job Number	37503A			Part Number	D412742043		
Estimate Number	10756			Drawing Number	D3391		
P.O. Number	:			Project Number	N/A		
This Issue	2/20/2008	S.O. No.	:	Drawing Revision	G		
Prsht Rev.	NC			Material	:		
First Issue	1/	Type	LANDING GEAR	Due Date	3/17/2008	Qty:	1
Previous Run	35745A			Um:	Each		
Written By	<u>JLM</u>						
Checked & Approved By	<u>JLM</u>						
Comment	Est Rev A 05.10.13 New Issue Est Rev B 06.02.13 ECN 773 dwg @ rev.D Est Rev:C 07-05-28 As per Rev F Est Rev:D 07-12-04 ECN 1072 by:JLM			KJ/JLM EC JLM DD verified			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003		<i>N/A</i>
2.0	HAND FINISHING	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M10005

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241-291 M105585Expiry date: 08-07

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251A/R Sikaflex-241-291 M105585Expiry date: 08-07

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

08-05-08 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 37503A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

3.0 D3391023 Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-023 Mid Tube Assembly

B35767

11

4.0 D3391025 Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-025 Aft Tube Assembly

B36841

11

5.0 D35641 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B33243

11

6.0 D35661 GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B337410

11

7.0 D35643 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B33764

11

8.0 D35645 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B337212

11

9.0 D35665 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B337411

11

08-03-11

(x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:12:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 37503A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN3C4A BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: M107008

96

11.0 AN3C6A BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: M105300

10

*

12.0 AN3C7A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: M105906

91

13.0 AN960C10L washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: M107242

96

08-03-12

(1)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/12 (1)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: (P)

PPP Rev: 37503

8/3/13 50

6
2

(1)

16.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/14

Job Completion



2008/3/13

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

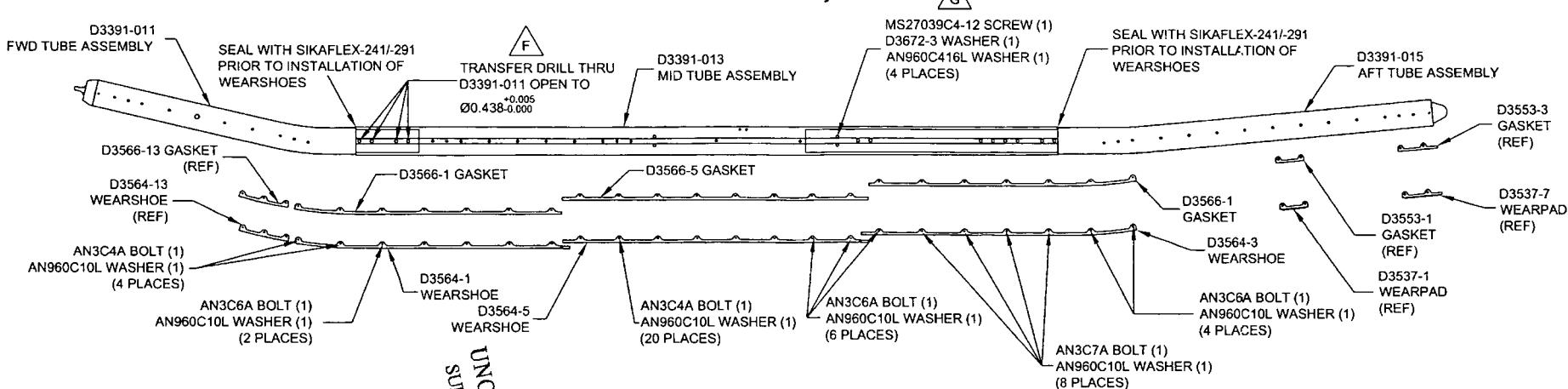
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

RELEASED
07-11-06

NO. 31503A

WORK ORDER

GENERAL NOTES

UNCONTROLLED SUBJECT TO AMENDMENT

RETURN TO ENGINEERING C.O.P.

SHOP COPY

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS2703C4-12	SCREW
4	AN960C416L	WASHER

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JK		
CHECKED	JK		
MFG. APPR.	JK		
APPROVED	JK		
DE APPR.	JK		
DATE	07.07.31		
DRAWING NO.	D3391	REV. G	
		SHEET 1 OF 8	
TITLE	412 FLOAT SKIDTUBE	SCALE	
		NTS	

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8 7 6 5 4 3 2 1

A

8 7 6 5 4 3 2 1

D

D

C

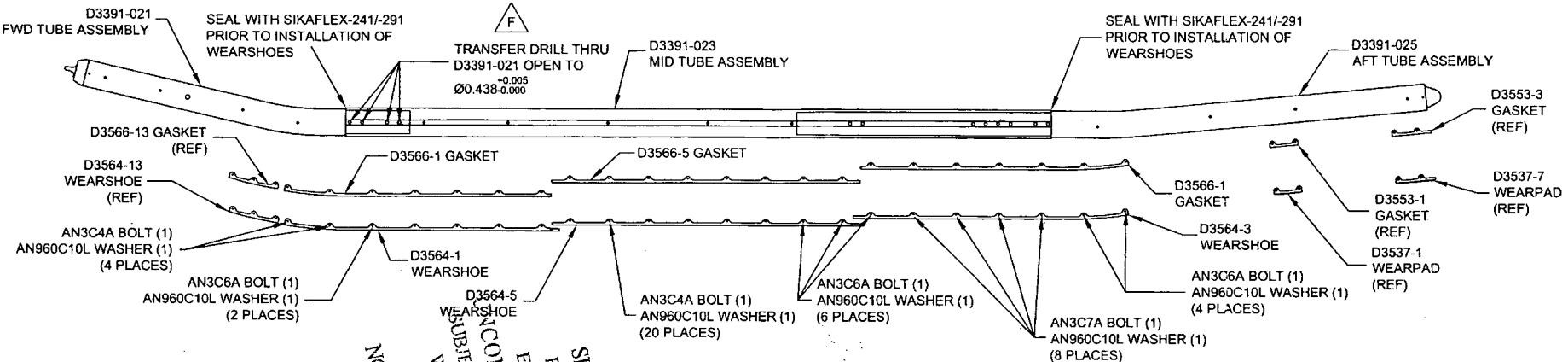
C

B

B

A

A



RELEASED
07.11.04
NO. 37503A
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
ENGINEERING
CONTROLLED COPY
RETURN TO
SHOP COPY

D3391-043 ASSEMBLY

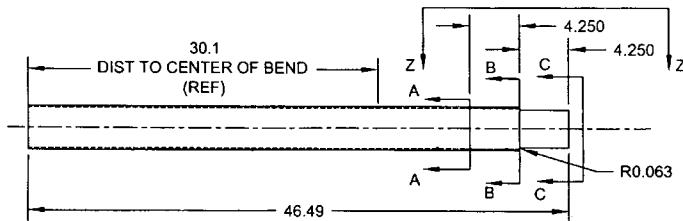
D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3568-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

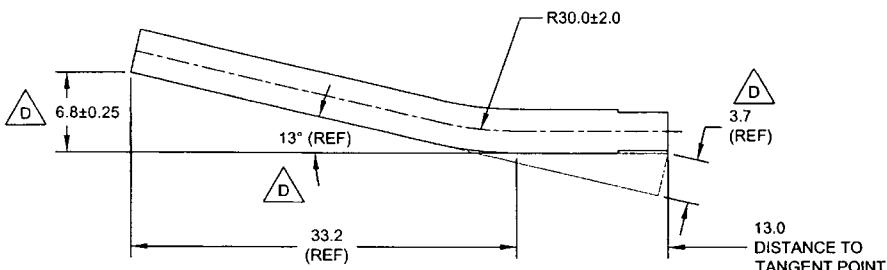
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

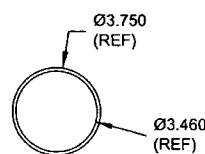
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC	
DRAWN	<i>JC</i>	PORT HADLOCK, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>AS</i>	D3391	SHEET 2 OF 8
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	412 FLOAT SKIDTUBE	NTS
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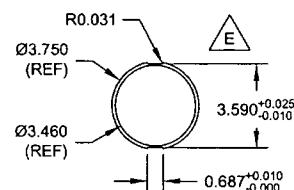
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



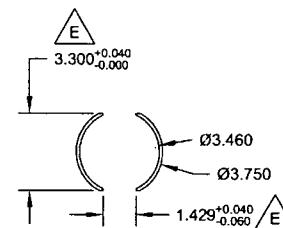
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



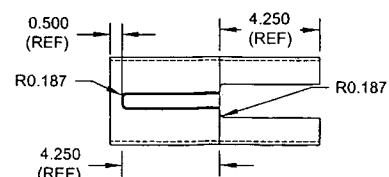
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SECTION B-B
(SCALE 1:5)



SECTION C-0
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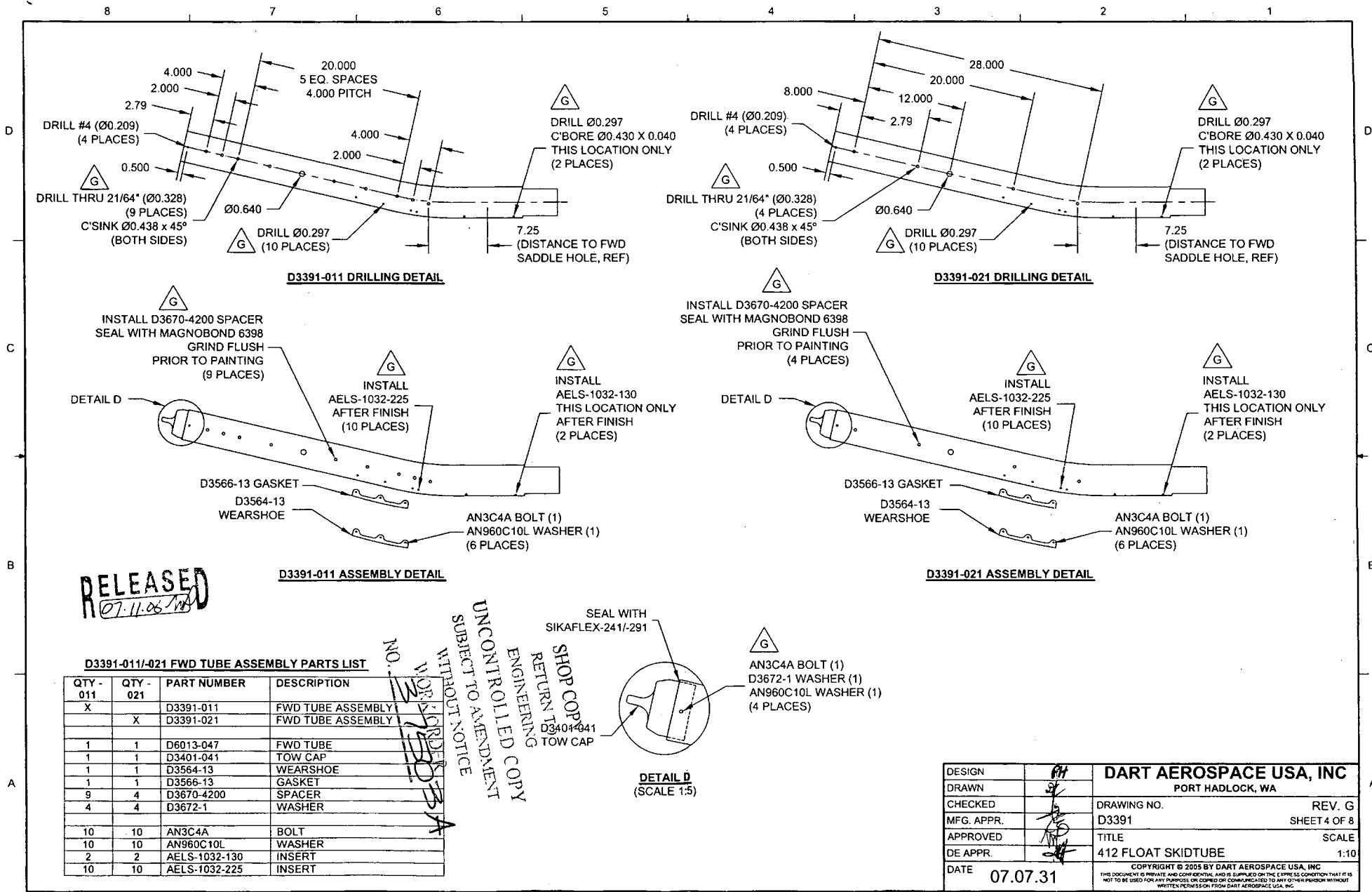


VIEW Z-Z
(SCALE 1:5)

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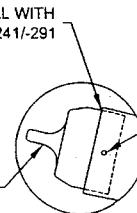
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CHECKED	<i>JL</i>	DRAWING NO.	REV. G	
MFG. APPR.	<i>CR</i>	D3391	SHEET 3 OF 8	
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DE APPR.	<i>SH</i>	412 FLOAT SKIDTUBE	1:10	
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D3391-011/021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AEELS-1032-130	INSERT
10	10	AEELS-1032-225	INSERT

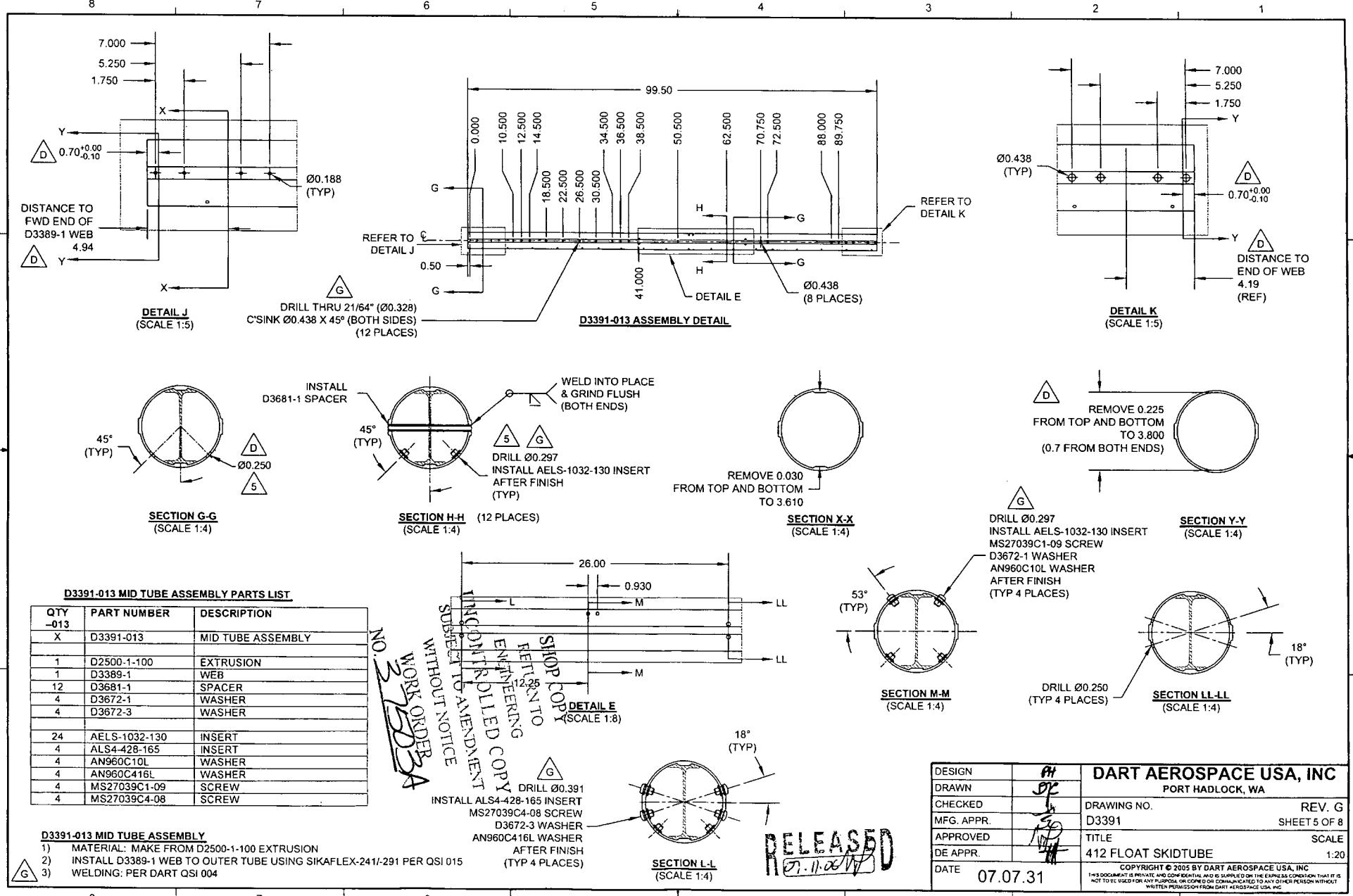
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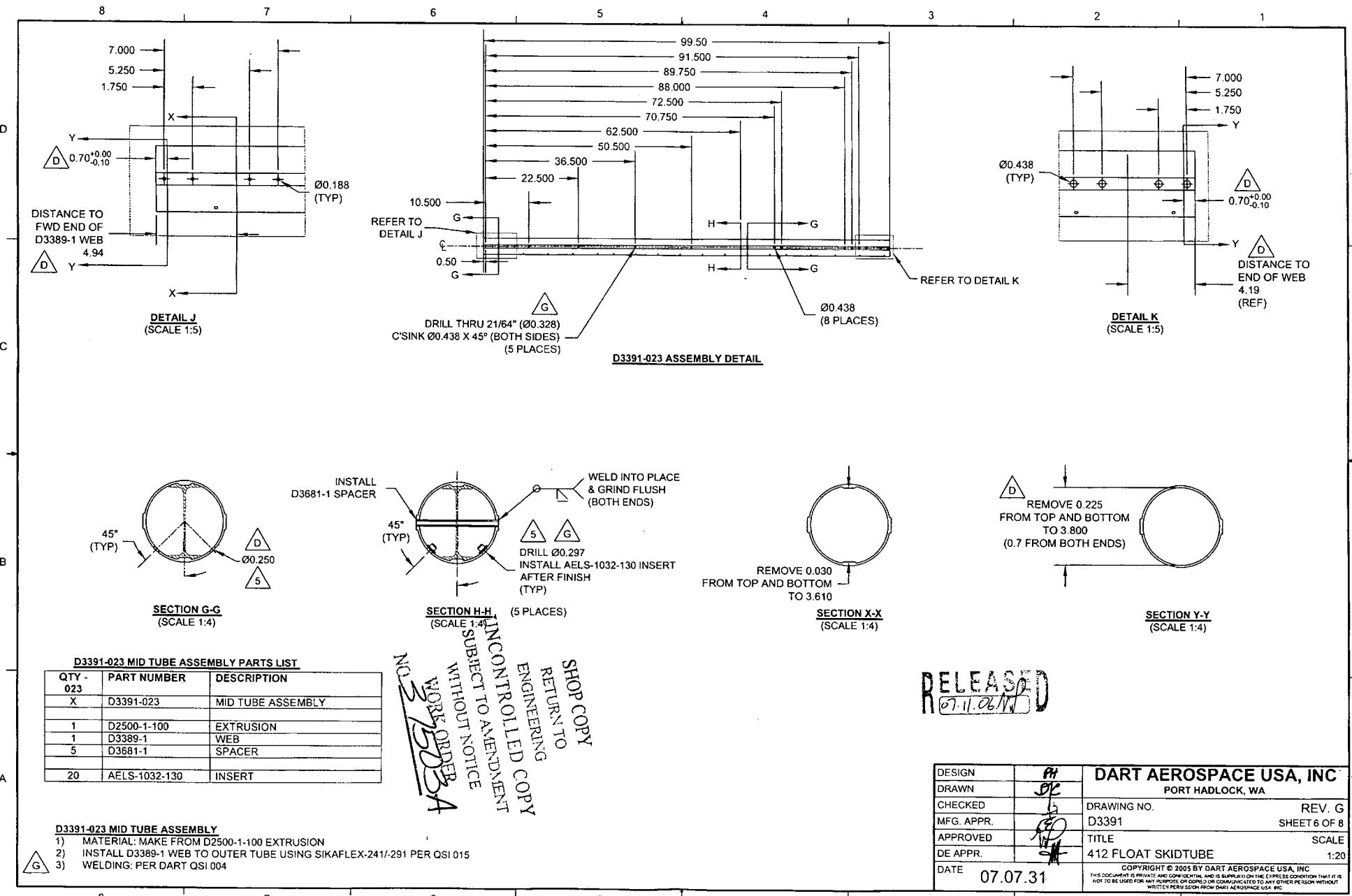


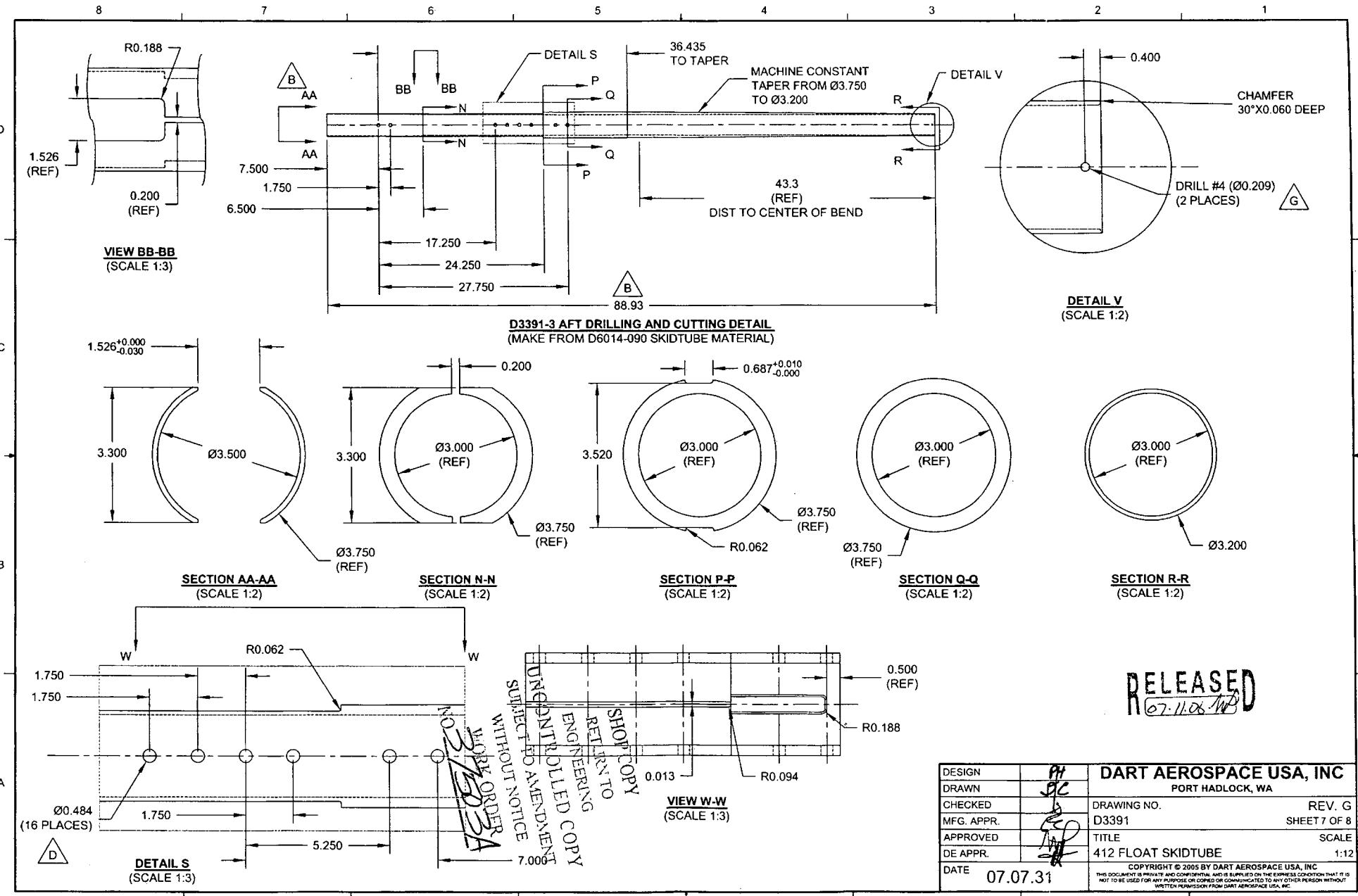
DETAIL D
(SCALE 1:5)

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MFG. APPR.	<i>SP</i>	D3391	SHEET 1 OF 8	
APPROVED	<i>TM</i>	TITLE	SCALE	
DE APPR.	<i>SP</i>	412 FLOAT SKIDTUBE	1:10	
DATE	07.07.31			

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APPROVED	S	TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:12
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